

## ABSTRACT

A method and apparatus utilizing a radial rolling process to cold form rings on a lead battery terminal with undercuts or overhangs to improve the sealing properties of the rings. The apparatus includes a fixture configured to securely position the battery terminal beneath a rolling station. The rolling station includes a radial rolling spindle having a plurality of cam shaped rollers configured to transform at least one ring on the battery terminal from having an initial rectangular cross-sectional shape into a desired arrowhead cross-sectional shape when the terminal and cold metal forming member are rotated relative to each other. A drive assembly is configured to rotate the battery terminal and radial rolling head relative to each other.